



Dart Aerospace Ltd.
1270 Aberdeen St
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RBEA62309-3
Job Sheet 190125



Part No: RBEA62309-3

Job Qty: 3 pcs

Part Name: Stiffener Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 3/1/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBEA62309 Rev.R IPP Rev. A 19.02.01 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S158534



Part: RBEA62309-3

Job No: 190125

Serial No/Batch: S158534

Revision: S

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/04/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	3/1/19	0.00	0.60		Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs	3/1/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50 70		288 19/02/4
120	Packaging 3-1 - Stock - B4B	3 pcs	3/1/19	0.00	0.00		Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		DAS
							Packaging 3 - 5 - B4B		28
							Packaging 3 - 6 - B4B		9-89
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	3 pcs	3/1/19	0.00	0.00		QC 21 - SA - 21		DAS 21 MAR 04 2019
							QC 21 - SA - 70		288

Part Op
Descriptions: 100 - Assemble as per DWG. See note 8.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
93286A013	Aluminum Washer 0.265" ID. X 0.688" OD.	24 (8 ea)	100-Small Fab - 1	515 2094
97447A651	Aluminum Blind Rivets 1/4" Dia. X 1/2" Long	24 (8 ea)	100-Small Fab - 1	515 2095
RBEA62309-4	Stiffener	3 pcs (1 ea)	100-Small Fab - 1	515 4662
RBEA62309-5	Handle	6 pcs (2 ea)	100-Small Fab - 1	515 3420

Job Allocations

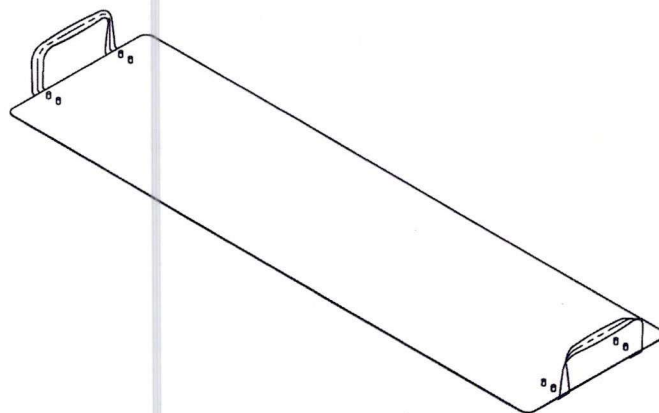
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	93286A013	24	0	0
	97447A651	24	0	0
	RBEA62309-4	3	0	0
	RBEA62309-5	6	0	0

Part Specifications

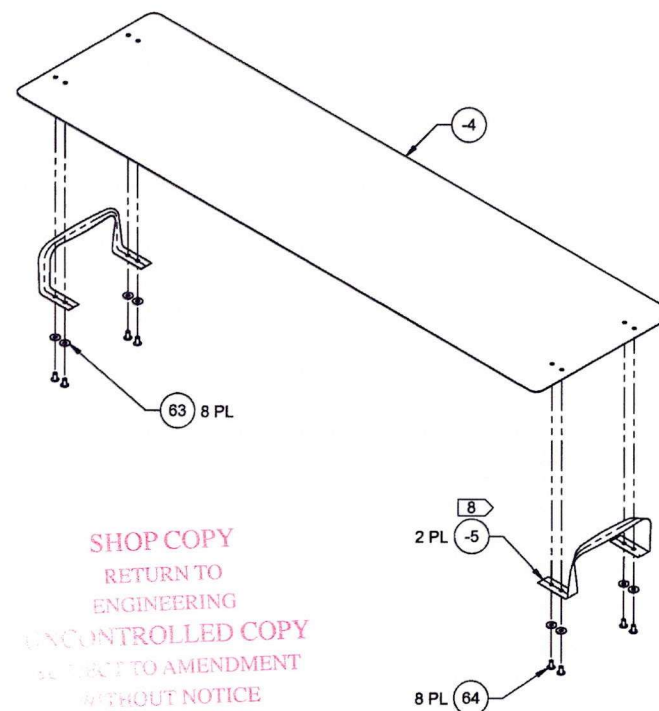
Specifications could not be found.

Plex 2/5/19 10:56 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-4	1	RBEA62309-4	STIFFENER
-5	2	RBEA62309-5	HANDLE
63	8	McMaster#93286A013 OR EQUIV.	ALUMINUM WASHER 0.265" ID. X 0.688" OD.
64	8	McMaster#97447A651 OR EQUIV.	ALUMINUM BLIND RIVETS 1/4" DIA. X 1/2" LG.



RBEA62309-3 STIFFENER ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
DO NOT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

190125 MJS
19 02 05

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) INSTALL ITEMS -5 ONTO ITEM -4 USING ALUMINUM RIVETS (ITEM 64)

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. R
MFG. APPR.	DP	RBEA62309	SHEET 8 OF 11
APPROVED	VJP	TITLE	SCALE
DATE	1/24/2019	AS350/355 FIELD MAINTENANCE KIT	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					